

Work Order ID 50906

July 24, 2009 4:08:07 PM



Page 1

Item ID: D3947-2
Revision ID: A
Item Name: Panel, Upper RH Post

Accept



Setup Start



Stop



Start Date: 07/24/2009 Start Qty: 4.00

Required Date: 07/31/2009 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-07-24 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3947

A

100

0.00



HAND FINISHING THERMOFORMING

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Cut Blanks to fit frame size

M119573

BB 09/07/28 (X4)

28x52

110

0.00



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-up

2-Pre-heat tool

3-Thermoform as per Dwg. D36476-1 and Folio FTA 045 using tool DT9483

Dwg. Rev. A

Folio Rev. A

BB 09/07/28 (X4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Visually inspect for proper formation of each part

BB 09/07/30 (X4)

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

BB 09/07/30 (X4)

140

HAND FINISHING THERMOFORMING

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions as per dwg D3946-1

BB 09/07/30 (X4)

W/O:		WORK ORDER CHANGES					
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Required Date: 07/31/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Check dimensions to ensure conformity to drawing tolerances.

BB 09/07/30 xy

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

=> 50907/31

(xy) x

170



Packaging

Packaging

Identify as per dwg & Stock Location

PPP
50903

0.00

Memo

0.00

yx PC 8/7/31

W/O:		WORK ORDER CHANGES					
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Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/31 *[Signature]*
MF 09-07-31

W/O:		WORK ORDER CHANGES					
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Picklist Print

July 24, 2009 4:08:07 PM

Page 1

Work Order ID: 50906

Parent Item: D3947-2RevA

Parent Item Name: Panel, Upper RH Post

Comments:

Start Date: 07/24/2009

Required Date: 07/31/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,992.616	13.9179			



GE PLASTICS LEXAN SHEET

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

1992.6166

107574

16.62

111973

797.33

112176

1178.6666

M1119 273
DB 09/07/01

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD	Work Order:	50906
Description: Upper RH Post	Part Number:	D3947-2
Inspection Dwg: D3947 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 09/07/30

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.0		10.1	✓			
0.2	Min	.232	✓			
0.5	Min	.565	✓			
1.8		1.863	✓			
3.1	REF	3.4	✓			
26.6	REF	26.625	✓			
0.050	Min	0.055	✓			
0.070	Min	0.088	✓			

Measured by: BB

Date: 09/07/30

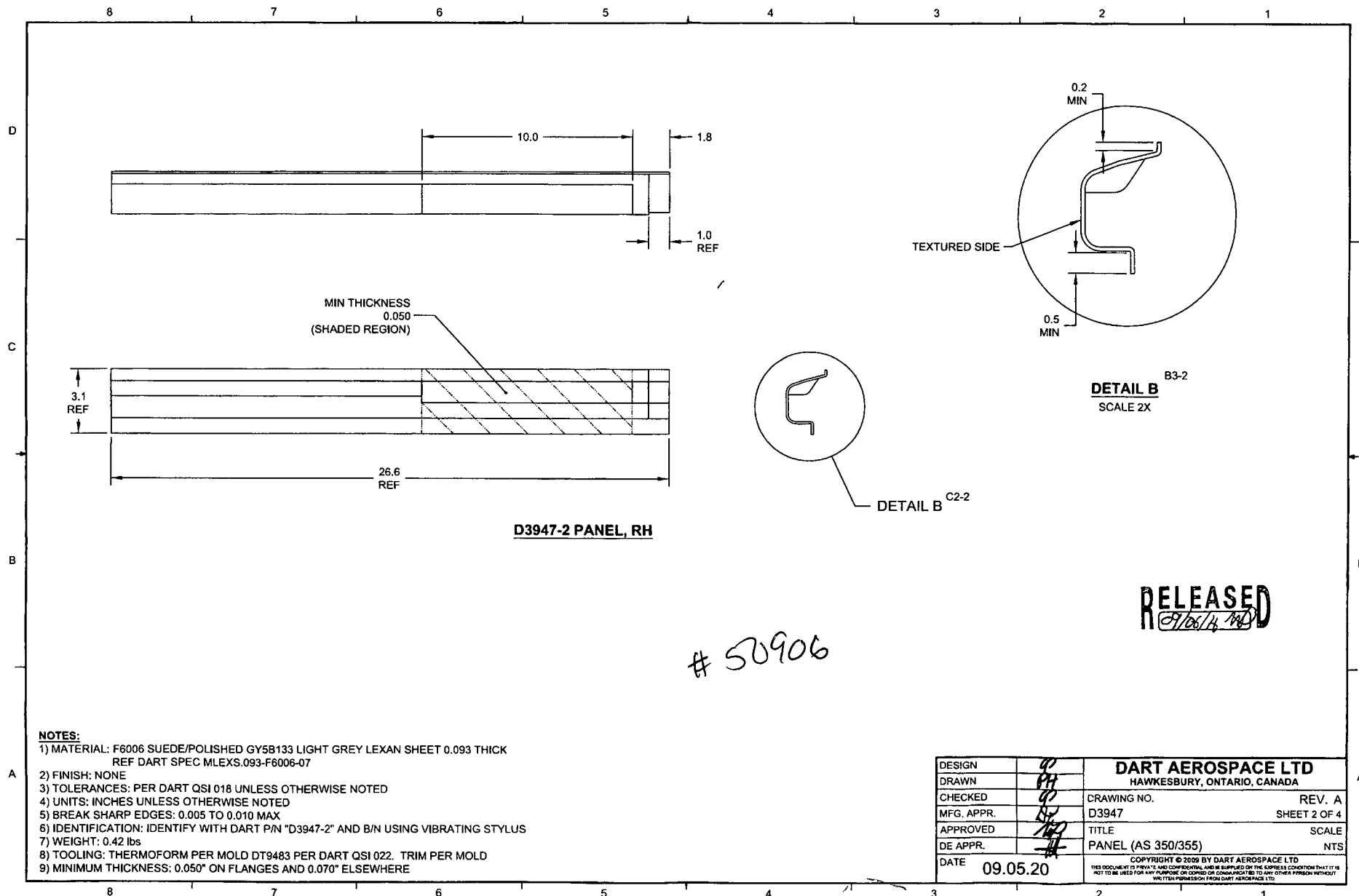
Audited by: S

Date: 09/07/30

Prototype Approval: n/n

Date: n/a

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



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